



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D4131-043
Job Sheet 174867



Part No: D4131-043

Job Qty: 4 ea 60

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 4/10/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,9 IPP Rev:A 10.10.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/9/18	0.00	0.00	Start Up Waterjet		SL 18/03/2018
100	Waterjet	4 pcs		4/9/18	0.00	0.45	Waterjet1		SL 18/03/2018
120	QC	4 pcs		4/9/18	0.00	0.00	QC8		DAS 38 9-85
130	Small Fab	4 pcs		4/9/18	0.00	0.25	Small Fab-6		SL 18-04-04
150	QC	4 pcs		4/9/18	0.00	0.00	QC5		DAS 38 9-85
160	HandFinish	4 pcs		4/9/18	0.00	0.23	HandFinish1		SL 18-04-04
161	QC	4 pcs		4/9/18	0.00	0.00	QC7-3		DAS 38 9-85
165	Small Fab	4 pcs		4/10/18	0.00	0.25	Small Fab-6		DAS 38 9-85
166	QC	4 pcs		4/10/18	0.00	0.00	QC5		DAS 38 9-85
180	Packaging	4 pcs		4/10/18	0.00	0.00	Packaging3-2		SL 18-04-04
190	QC21-SA	4 Ea		4/10/18	0.00	0.00	QC21		APR 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.7228 sf (.1807 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	32 Ea (8 ea)	165-Small Fab	50185354
MS21069L3	Anchor Nut	16 Ea (4 ea)	165-Small Fab	503440012x
				5050044 12x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	1	153	0
165-Small Fab	MS20426AD3-3	32	5,648	0
	MS21069L3	16	242	0



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Container No: S055693



Part: D4131-043

Job No: 174867

Serial No/Batch: S055693

Revision:

Inspector:

Date: 03/27/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	0,099	Diameter
2	Doubler Assembly	0.191Inches + 0.005 - 0.001	0.196 0.190	0,190	Diameter
3	Doubler Assembly	0.250Inches ± 0.010	0.260 0.240	0,252	
4	Doubler Assembly	0.500Inches ± 0.010	0.510 0.490	0,501	
5	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0,406	
6	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0,405	
7	Doubler Assembly	0.590Inches ± 0.030	0.620 0.560	0,590	
8	Doubler Assembly	0.660Inches ± 0.030	0.690 0.630	0,660	
9	Doubler Assembly	3.640Inches ± 0.030	3.670 3.610	3,643	
10	Doubler Assembly	4.000Inches ± 0.010	4.010 3.990	4,001	
11	Doubler Assembly	4.100Inches ± 0.030	4.130 4.070	4,103	
12	Doubler Assembly	4.810Inches ± 0.030	4.840 4.780	4,814	
13	Doubler Assembly	4.600Inches ± 0.010	4.610 4.590	4,606	
14	Doubler Assembly	5.410Inches ± 0.030	5.440 5.380	5,418	
15	Doubler Assembly	0.063Inches ± 0.010	0.073 0.053	0,060	

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